

Date: Monday, 2/25/2008 11:15:11 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : D119 HELI UTILITY BASKET PRELIM  
 Job Number : 37591  
 Estimate Number : 12452  
 P.O. Number : Part Number : D119756041  
 This Issue : 2/25/2008 S.O. No. : Drawing Number : IIN PG11-12  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 1 / Type : LARGE FAB ASSY Drawing Revision : C  
 Previous Run : 37590 Material :  
 Written By : Due Date : 3/17/2008 Qty: 1 Um: Each  
 Checked & Approved By : 08.02.26  
 Comment : Est Rev. A New Issue 06-06-14 JLM  
 Est Rev. B 06.07.26 dwg revB, picklist EC  
 est rev C revC dwg 07.04.09 EC

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

RS 08/03/17

2.0 37591A BASKET LID ASS'Y (A119)



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

B 37591A mf

3.0 37591B BASKET BASE ASS'Y (A119) PRELIMINARY



Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

B 37591B mf 08-03-16

4.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: 33485

B

5.0 D2258220 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 30810

C

6.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

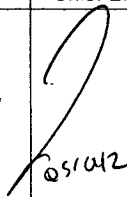
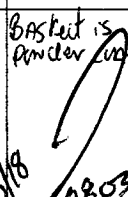
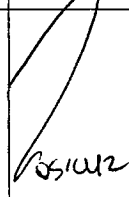
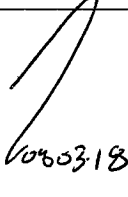
Batch: 35718

B 8/3/14 C

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: 1 Date: 08/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/18	2+3	concerns of welds on msh - not robust enough	 05/04/18	re-inspect welds conclusion: acceptable	PD 02/03/18 08/03/18	08/03/18  08/03/18	 05/04/18	 08/03/18

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:15:11 AM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37591

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 36657

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 36397

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 36853

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

Batch: 29576

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106815

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

  
8/3/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37591

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104937

*[Signature]*

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104847

*[Signature]*

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107242

*[Signature]*

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M106277

*[Signature]*

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M106785

*[Signature]*

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M106654

*[Signature]*

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M106918

*[Signature]* 8/3/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37591

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M105442

*PK*

22.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M18077

*PK*

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106242

*PK*

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105238

*PK*

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

*PK 8/3/14*

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

*mf*

08-03-16

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08-03-17 (1)*

25.1 2x D3757-1 B 34815  
25.2 6x AN310A B 14820  
25.3 12x AN960JD10 B 106552  
25.4 6x MS21042L3 B 106242

*08/3/17*

*per DS19405 see attached*

*08-03-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 37591

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP KIT

Batch: 31747

30.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

29991

31.0

D26175

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

35922

32.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CLEVIS

batch: 37619

33.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

STRUT

Batch: 31628

34.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

FWD ARM ASSEMBLY

Batch: 37621

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/25/2008 11:15:12 AM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37591

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D35201

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
SPACER 29578

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: MW 6993

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
Batch: M106375

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
batch: M16895

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
batch: M106515

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)  
Washer  
Batch: M106277

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer M106785

8/3/08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:15:12 AM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37591

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M17685

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Batch:

M105938

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119

Location:

PPP Rev:

C

8/3/18

SCC

(12)

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

H200103/19

Job Completion



W080319

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

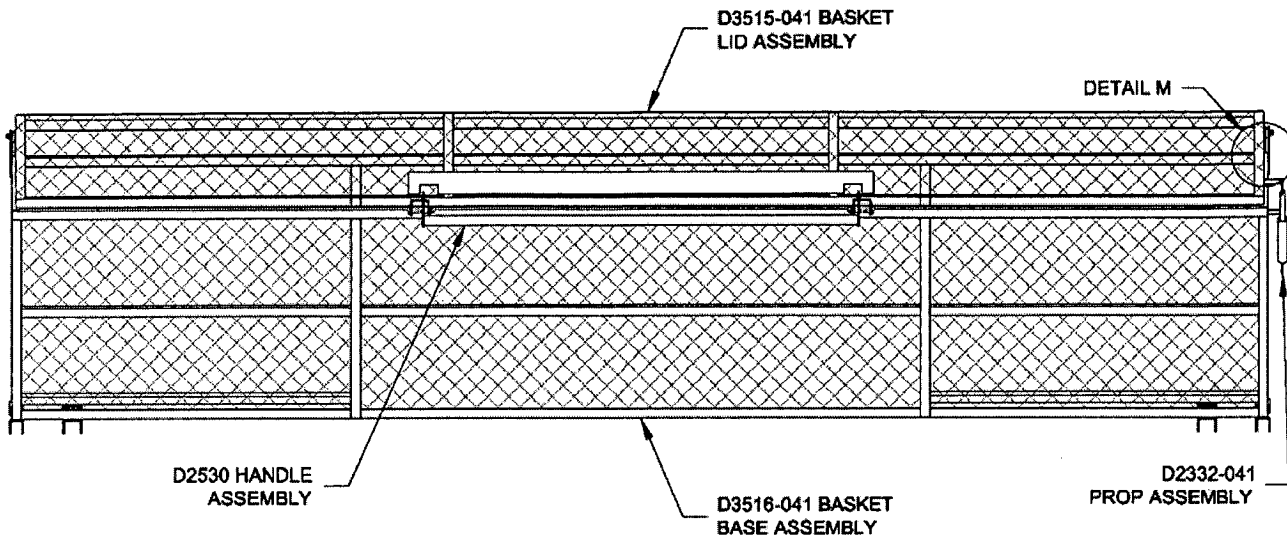
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description - Chief Eng	Sign & Date			

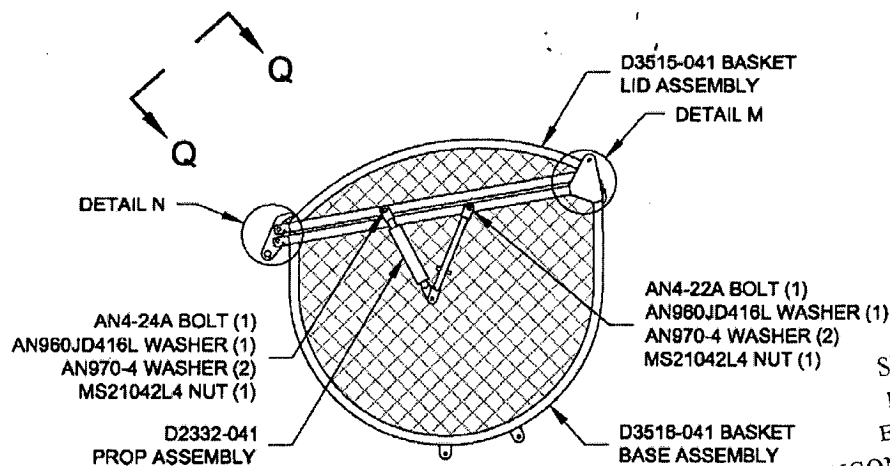
NOTE: Date & initial all entries

#### 4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart *Heli-Utility-Basket™* which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



**D119-756-041  
HELI-UTILITY-BASKET**



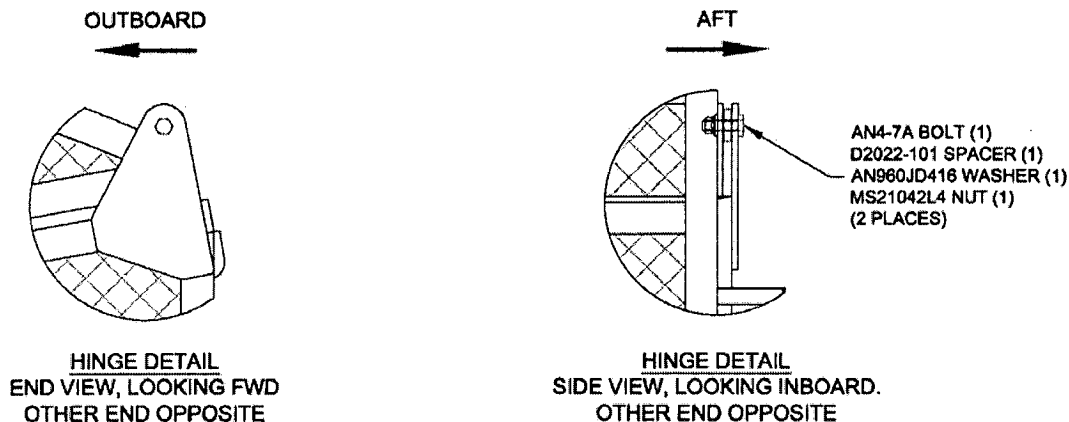
**VIEW C-C:  
PROP ARM DETAIL**

**Figure 4 – Basket Replacement Parts  
(D119-756-041 Heli-Utility-Basket™)**

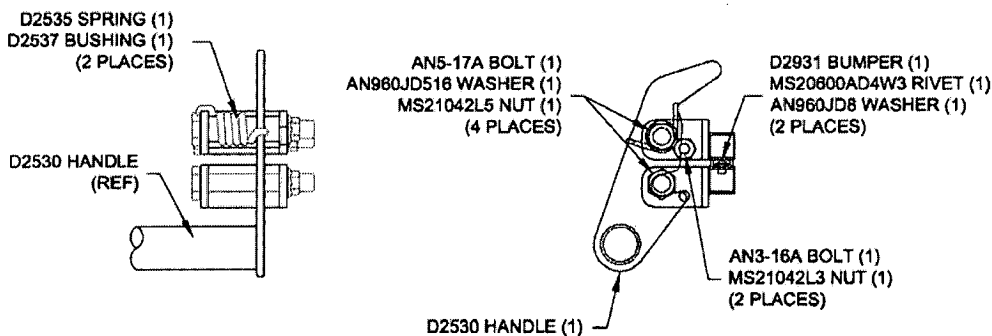
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WORK ORDER  
NO. 37591

Revision: **C**  
Date: 06.10.23



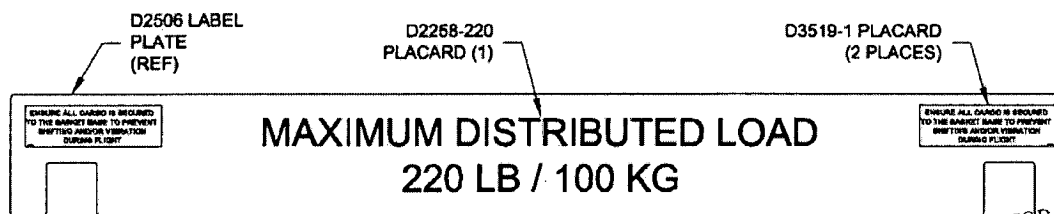
DETAIL M: HINGE



SPRING DETAIL

LATCH DETAIL

DETAIL N: HANDLE WELDMENT



VIEW Q-Q: PLACARDS  
ONLY PLACARDS AND  
LABEL PLATE SHOWN

**Figure 5 – Basket Replacement Parts & Placards**  
(D119-756-041 Heli-Utility-Basket™)

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WORK ORDER  
NO. 37591



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-756 REV. C &  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-756 REV. 0

REF. TCCA STC SH06-39

REF. FAA STC SR02364NY

ON THE D119-756-041 HELI-UTILITY-BASKET AT CHG 002 OR LATER, THE FORWARD AND AFT ENDS OF THE D3516-041 BASKET BASE ASSEMBLY HAVE BEEN UPGRADED WITH HOOPS AND FITTED WITH D3757-1 BLANKING PLATES. THE D3757-1 BLANKING PLATES MUST REMAIN INSTALLED OVER THE OPENINGS AT THE FORWARD AND AFT ENDS OF THE BASKET. REFER TO FIGURE 1 ON SHEET 2 OF THIS SERVICE INSTRUCTION.

THE PARTS LIST ON PAGE 14 OF IIN-D119-756 REV. C AND ON PAGES 41 AND 43 OF ICA-D119-756 REV. 0. SHOULD BE UPDATED AS FOLLOWS:

QTY -041	PART NUMBER	DESCRIPTION
X	D119-756-041	HELI-UTILITY-BASKET™
2	D3757-1	BLANKING PLATE <sup>3780</sup> <i>B3780/37805</i>
6	AN3-10A/11A	BOLT <i>14820</i>
12	AN960JD10	WASHER <i>106552</i>
6	MS21042L3	NUT <i>106242</i> (OR MS21042-3)

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WITHOUT NOTICE  
WORK ORDER  
NO. *37591*

**PRELIMINARY ISSUE**  
*08.02.22*

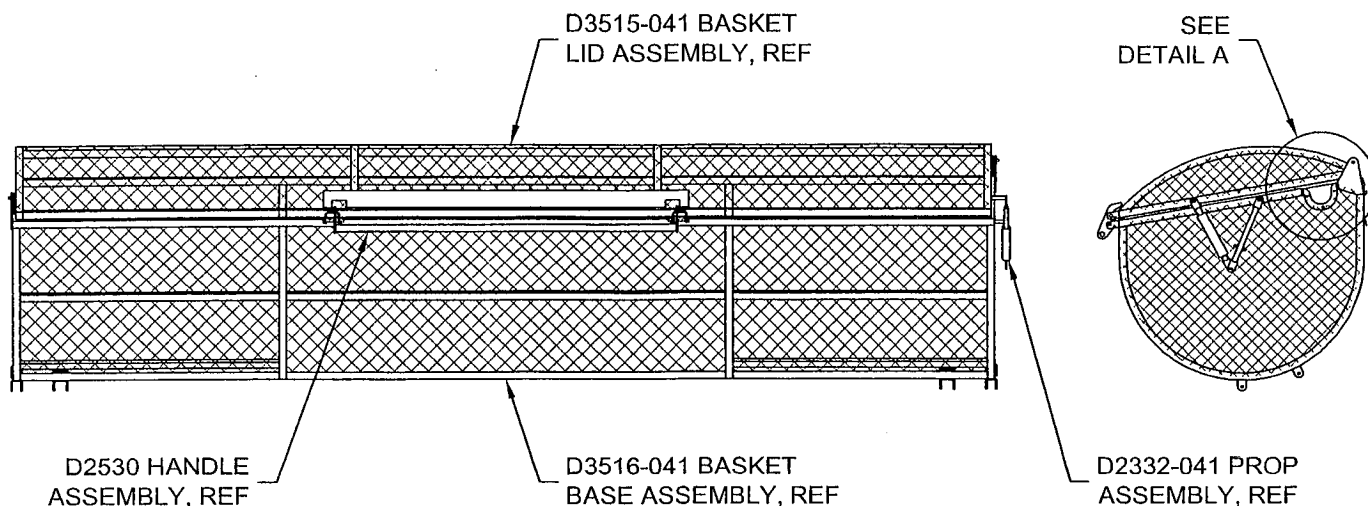
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

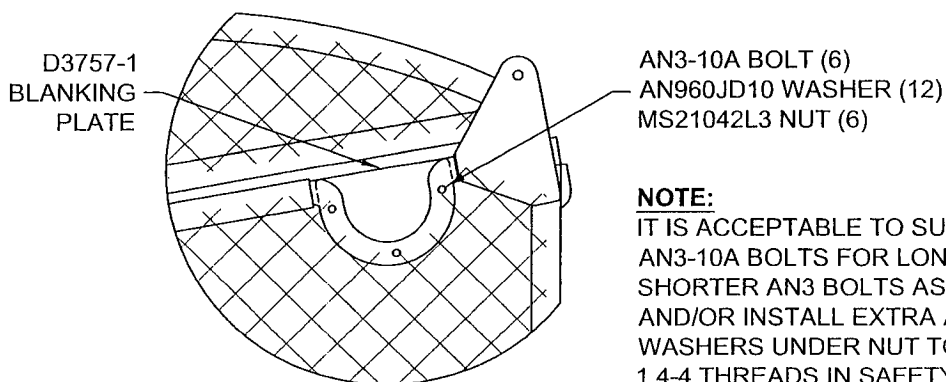
BY: \_\_\_\_\_  
D. SHEPHERD (DE # 02)

DATE: 08.02.22  
CERT. NO.: SH06-39  
ISSUE NO.: 1

A	NEW ISSUE	MB	08.02.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>12</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>CE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ME</i>	DRAWING NO.	REV. A
MFG. APPR.		DSI 9403	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
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**FIGURE 1 - D119-756-041 HELI-UTILITY-BASKET**



**DETAIL A - HOOP**  
SCALE 4X  
TYP, BOTH ENDS

**NOTE:**  
IT IS ACCEPTABLE TO SUBSTITUTE THE AN3-10A BOLTS FOR LONGER OR SHORTER AN3 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD10 WASHERS UNDER NUT TO ENSURE 1.4-4 THREADS IN SAFETY.

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER 37591

**PRELIMINARY ISSUE**

08.02.22

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: D. SHEPHERD (DE # 02)

DATE: 08.02.22  
CERT. NO.: SH06-39  
ISSUE NO.: 1

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9403	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-756 REV. C &  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-756 REV. 0

REF. TCCA STC SH06-39

REF. FAA STC SR02364NY

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THE PARTS LIST ON PAGE 14 OF IIN-D119-756 REV. C AND ON PAGES 41 AND 43 OF ICA-D119-756 REV. 0. SHOULD BE UPDATED AS FOLLOWS:

QTY -041	PART NUMBER	DESCRIPTION
X	D119-756-041	HELI-UTILITY-BASKET™
2	D3757-1	BLANKING PLATE 37473 2x B 37815 2x
6	AN3-10A	BOLT M14820
12	AN960JD10	WASHER M10652
6	MS21042L3	NUT M10622 (OR MS21042-3)

ll 810377  
per change  
on POS

SH06-39  
TCCA  
STC  
DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA  
08.02.22

PRELIMINARY ISSUE  
08.02.22

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01  APPROVED  BY: _____ D. SHEPHERD (DE # 02)  DATE: 08.02.22 CERT. NO.: SH06-39 ISSUE NO.: 1
--

A	NEW ISSUE	MB	08.02.22
REV.	DESCRIPTION	BY	DATE
DESIGN	12	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	12	DRAWING NO. REV. A DSI 9403 SHEET 1 OF 2	
CHECKED	12	MFG. APPR.	
APPROVED	12	TITLE SCALE BASKET BASE ASS'Y CHANGE NTS	
DE APPR.	12	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.02.22		

12

Date: Monday, 2/25/2008 11:15:19 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASS'Y (A119)
Job Number	: 37591A		
Estimate Number	: 12445		
P.O. Number	:	Part Number	: D3515041
This Issue	: 2/25/2008 S.O. No. :	Drawing Number	: D3515 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37590A	Material	:
Written By	:	Due Date	: 3/17/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>HA 08 06 26</u>		
Comment	: EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B35684

FC 08 03 13

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: B36860

PD 08-03-10

3.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B31693

PD 08-03-10

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B35585

PD 08-03-10

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481

PD 08-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:15:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37591A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube .75x.75x.065W

Batch: M107315

SAD 08/03/07

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

SAD 08/03/07 ⑩

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

PD 08-03-0

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1208/03/10

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: m10-1218

FC 08 03 13

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

FC

2-Cut expanded metal for base ends as per dwg D3516

FC

3-Weld expanded metal to base as per dwg D3516

FC

08 03 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 02/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:15:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37591A

Part Number: D3515041

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-03-14 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D 08-03-14 (1)

14.0

POWDER COATING

POWDER COATING



M10700 S



(X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-H

08/03/15

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A-m 08-03-15 (1)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk: M107385

black spray paint: M107230

A-m 08-03-15 (1)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 08/03/15

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GIA

MF 08-03-16 (1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/03/19

Job Completion



W 08-03-19



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

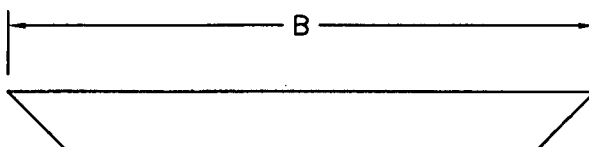
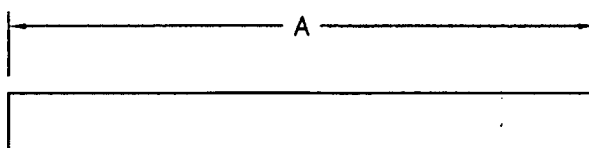
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CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

**RELEASED**

06.11.17 H

**PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH		DESCRIPTION
		A	B	
D3515-1	2 ✓	—	25.50	RIB
D3515-3	2 ✓	—	101.30	RIB
D3515-5	6 ✓	33.84	—	RIB
D3515-7	3 ✓	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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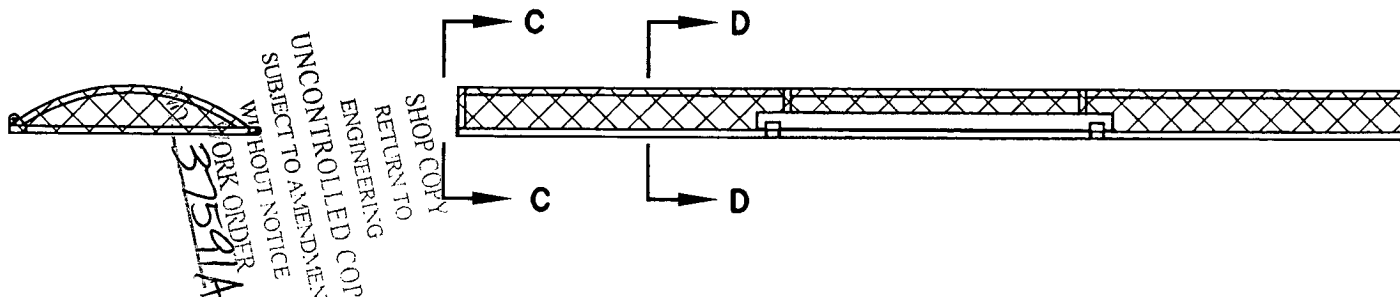
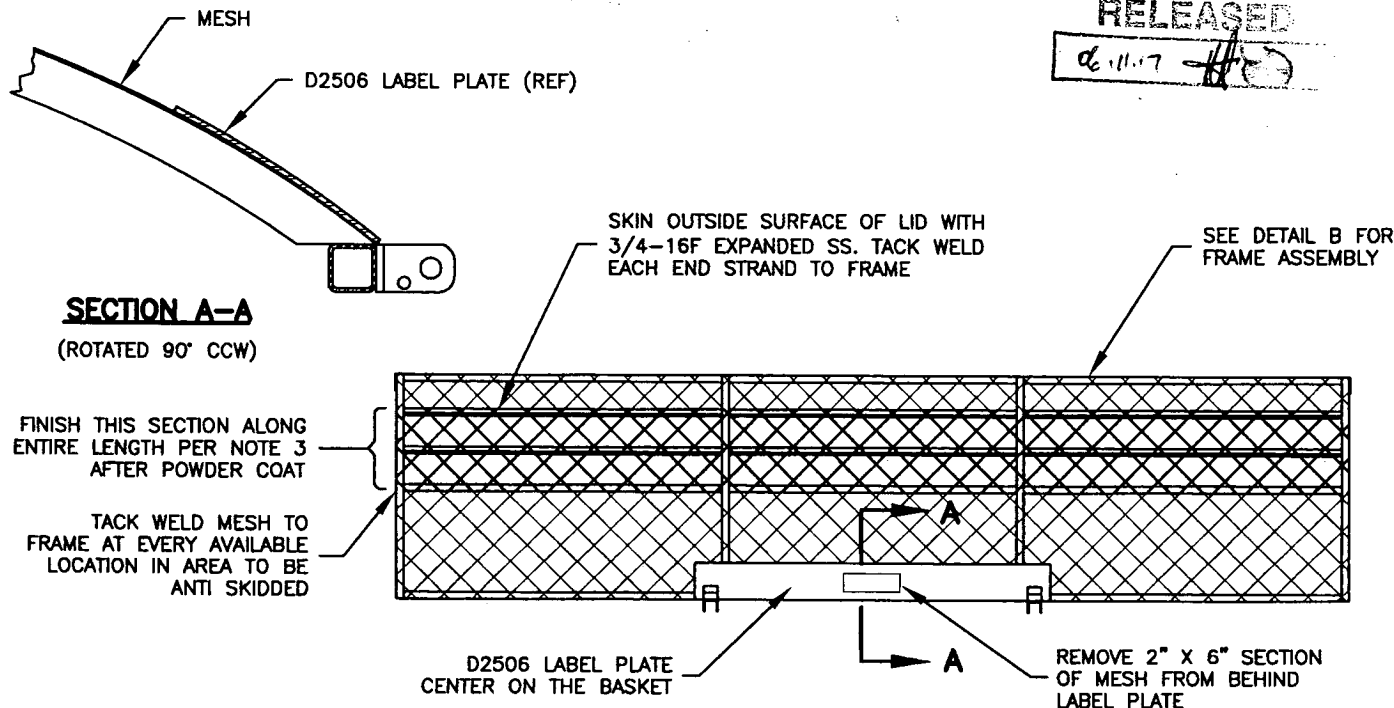
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 2 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20

RELEASED

06.11.07

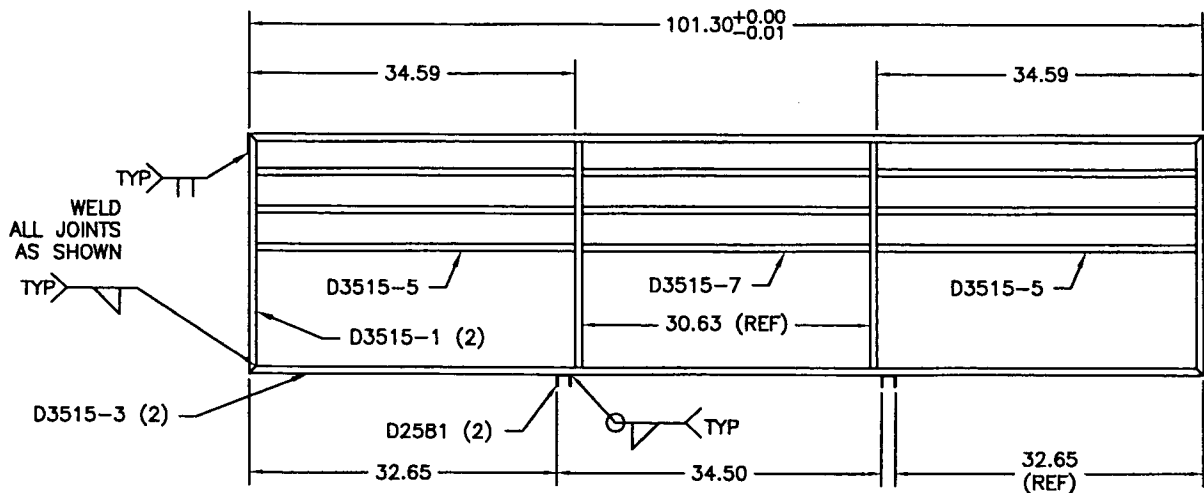


#### D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

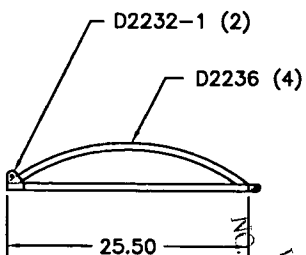
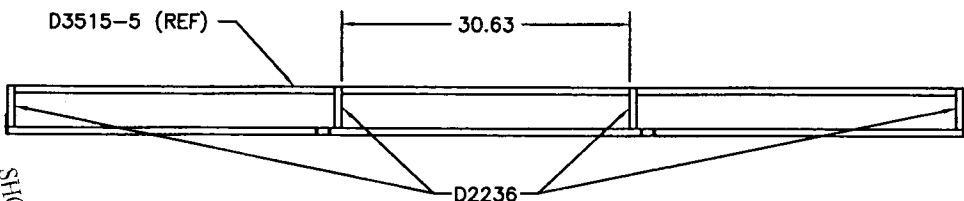
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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 3 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20



**DETAIL B**

FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

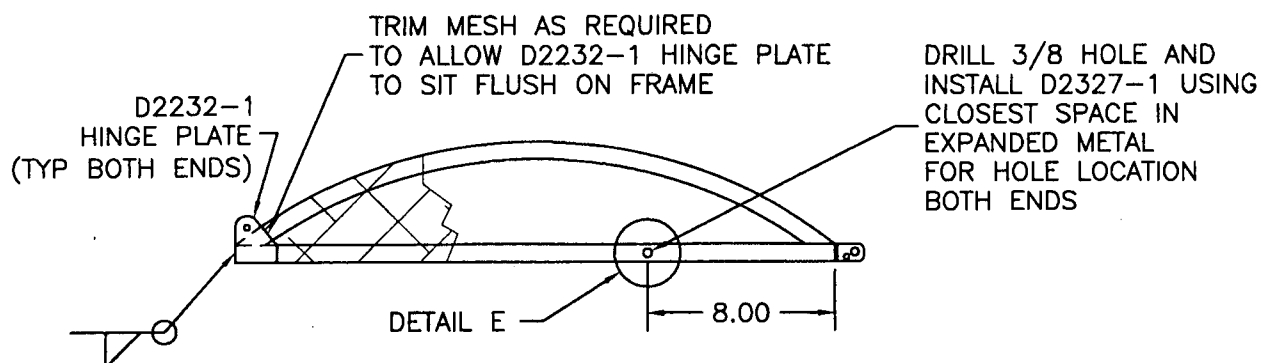


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06.11.17

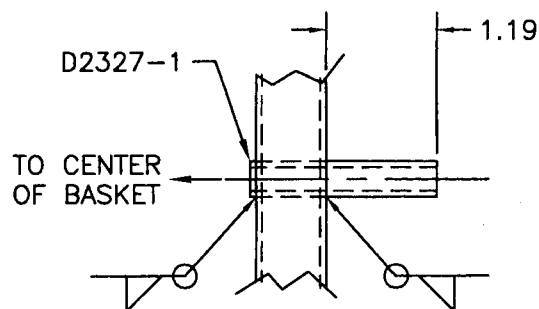


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

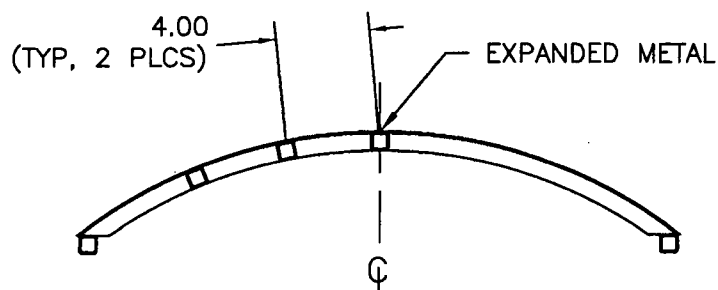


**SECTION C-C SIMILAR BOTH END RIBS**

RELEASED  
06-11-17 H



**DETAIL E**



**SECTION D-D SAME BOTH CENTER RIBS**

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Date: Monday, 2/25/2008 11:15:29 AM  
 User: Kim Johnston

## Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASS'Y (A119) PRELIMINARY  
 Job Number : 37591B  
 Estimate Number : 12431  
 P.O. Number :  
 This Issue : 2/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3516041  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3516 REV C PREMIL  
 Previous Run : 37590B Drawing Revision : C  
 Written By : Due Date : 3/17/2008 Qty: 1 Um: Each  
 Checked & Approved By : JA 08 02 26  
 Comment : EST rev. A 06.05.31 Preliminary EC  
 EST rev. b 06.07.27 updated EC  
 Est Rev:C 08-02-25 ECN 1138P DD verified by:



PRELIMINARY ISSUE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Shim  
 Batch: B34610  
A24246

FC 08 03 13

2.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Mounting Bracket  
 Batch: B36481

PD 08-03-13

3.0 D351611 CLEVIS



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 CLEVIS  
 batch: B31626

PD 08-03-13

4.0 D351613 CLEVIS



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 CLEVIS  
 batch: B31801

PD 08-03-13

5.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Spacer Bushing  
 Batch: B36697-1

PD 08-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/25/2008 11:15:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37591B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B36846

FC 08 03 13

7.0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B3658 B36859 -> 2

B37156-51

PD 08-03-13

8.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B37626

PD 08-03-13

9.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M107315

SAN 08/03/07

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5- Cut rib D3516-15 as per dwg D3516

6-Cut rib D3516-9 from D3166-1 (4)

SAN 08/03/07



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/25/2008 11:15:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37591B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Weld assembly as per dwg D3516

PD 08-03-13

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/08/03/13

13.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)  
Expanded Metal Flat Stainless steel  
Batch: M104219

FC 08 03 13

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut expanded metal for base as per dwg D3516

FC

2-Cut expanded metal for base ends as per dwg D3516

FC

3-Weld expanded metal to base as per dwg D3516

FC

08 03 13

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-14

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-14

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M107005

M-1

08/03/15

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 08.03.15

(A)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/25/2008 11:15:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37591B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ymf

08-03-16

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8.03.19  
2008/03/19

POSITIVE RECALL

EFFECTIVE

08.02.27

AUTH

1

RELEASED

08.03.18

DATE

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

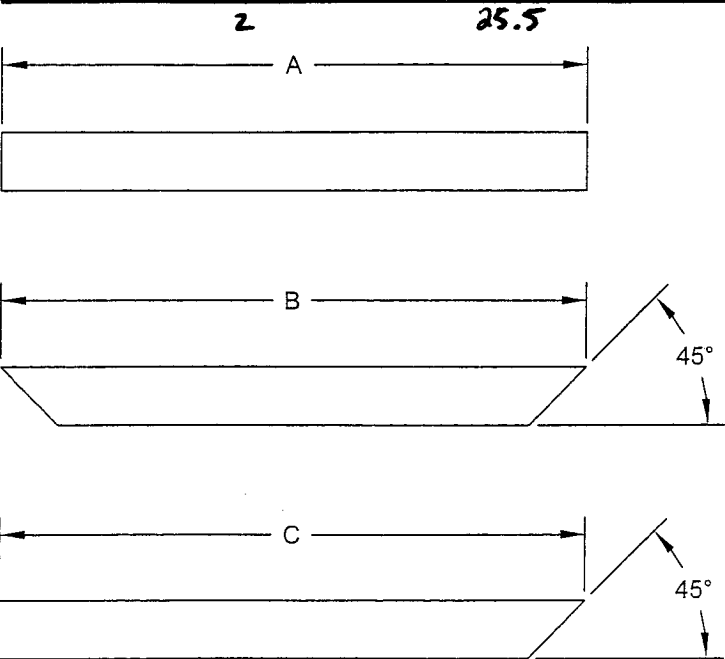
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3 ✓	2	N/A	N/A	N/A	HINGE PLATE
D2327-3 ✓	2	N/A	N/A	N/A	BUSHING
D2581 ✓	2	N/A	N/A	N/A	MOUNTING BRAKET
D3442-1 ✓	2	N/A	N/A	N/A	SHIM
D3516-1 ✓	2 ✓	—	102.00	—	RIB
D3516-3 ✓	2	—	—	2.70	RIB
D3516-5 ✓	8 ✓	26.75	—	—	RIB
D3516-7 ✓	3 ✓	45.50	—	—	RIB
D3516-9 ✓	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11 ✓	6	N/A	N/A	N/A	CLEVIS
D3516-13 ✓	4	N/A	N/A	N/A	CLEVIS
D3516-15 ✓	2	—	—	19.32	RIB
D3725-1 ✓	2	N/A	N/A	N/A	HOOP



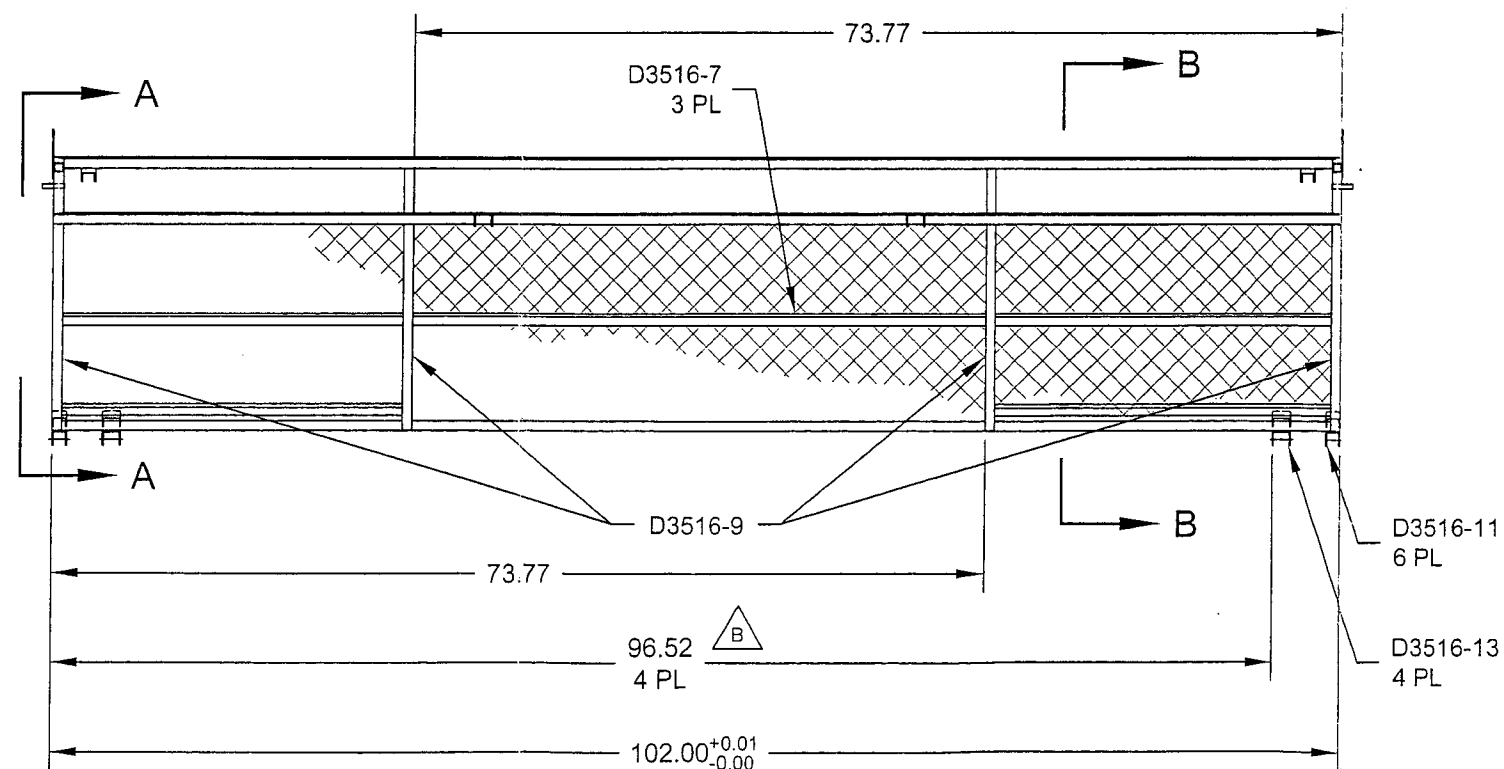
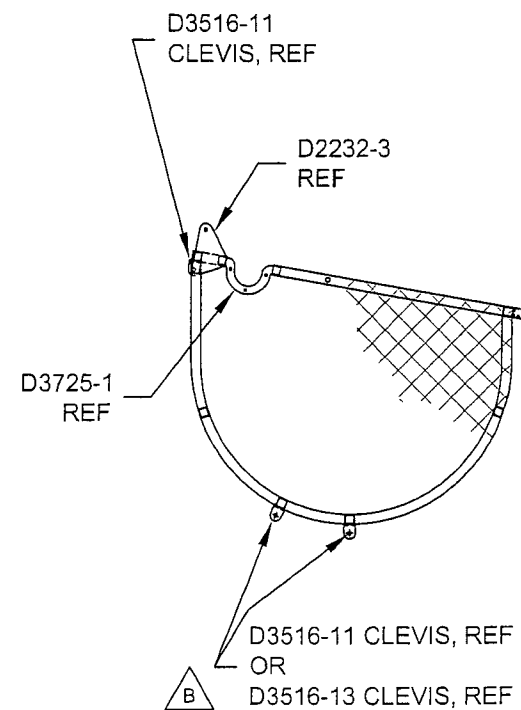
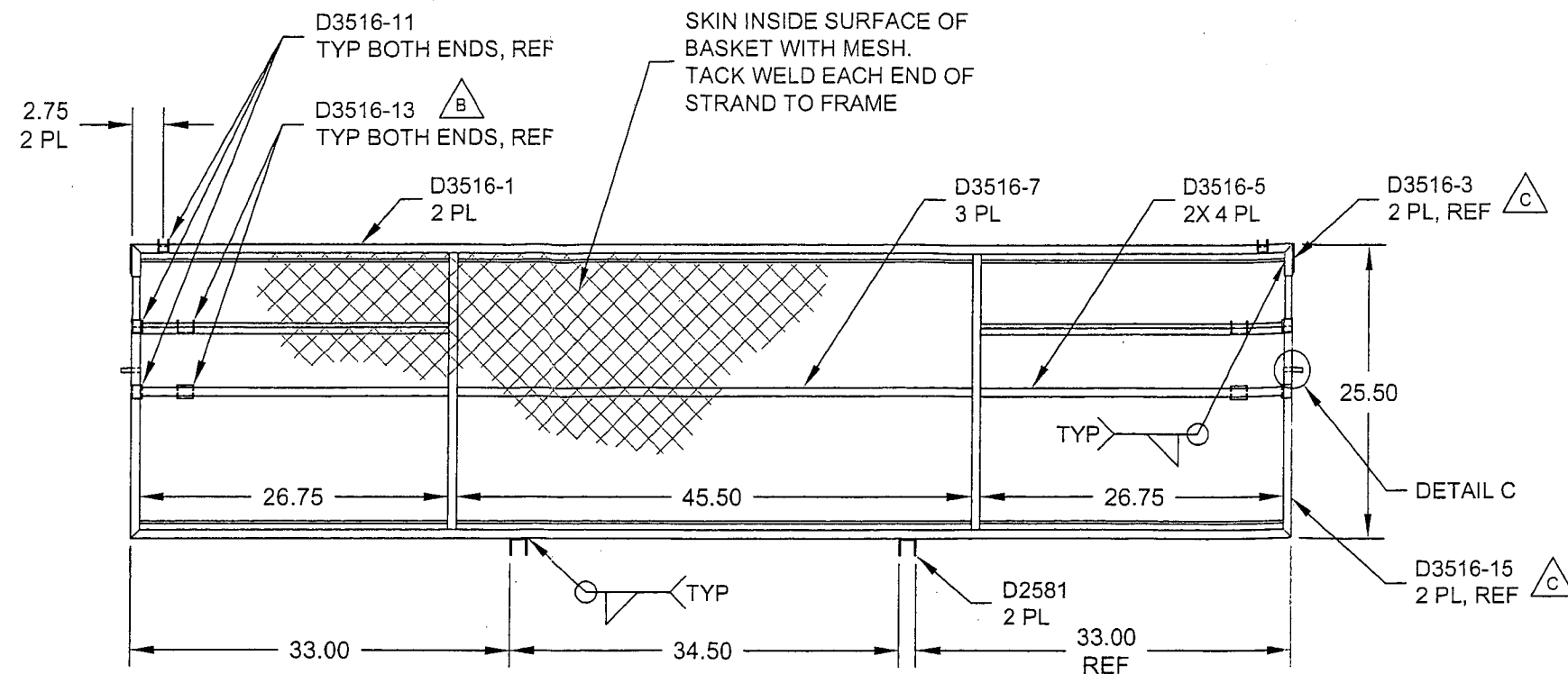
D3615-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:  
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL  
(REF. DART SPEC. M304TS0.750W.065)  
MESH - 3/4-16F EXPANDED STAINLESS STEEL  
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

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C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(8) D3516-11 WAS QTY.91) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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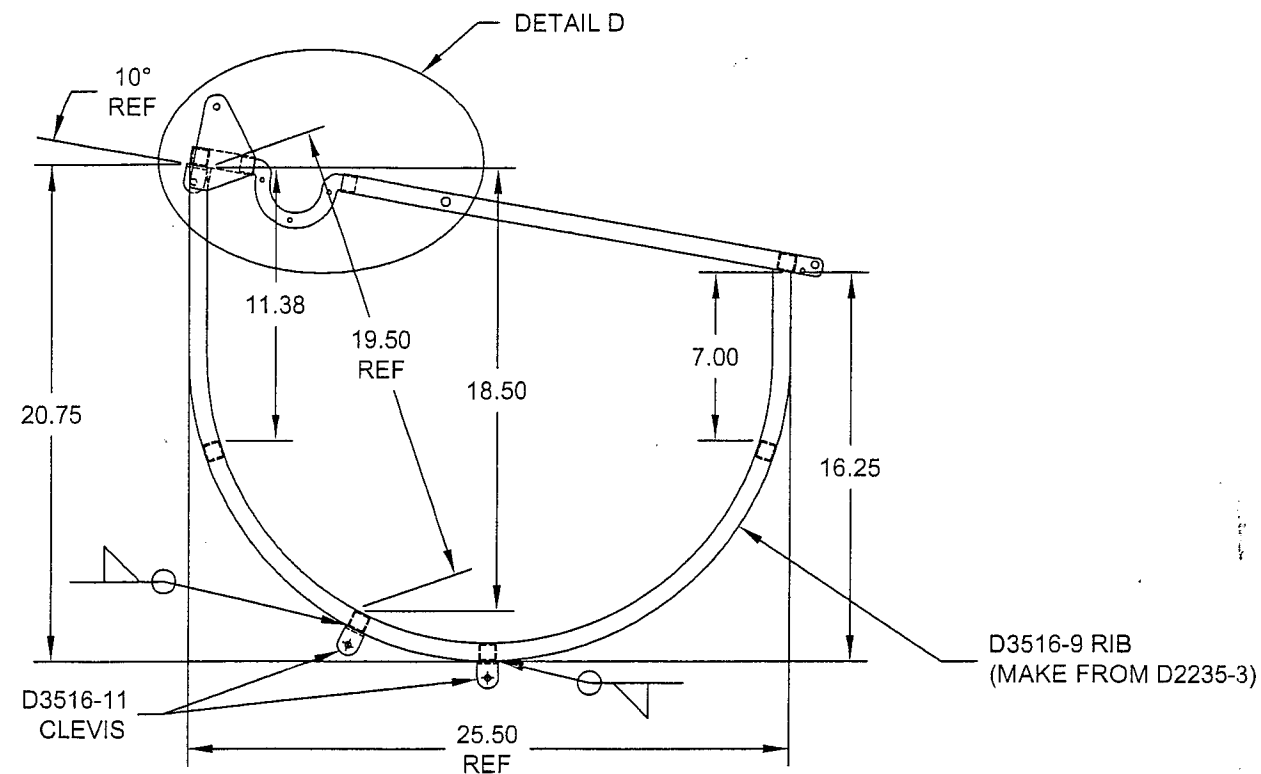
**PRELIMINARY ISSUE**  
10002-22

**D3516-041 BASKET BASE ASSEMBLY**

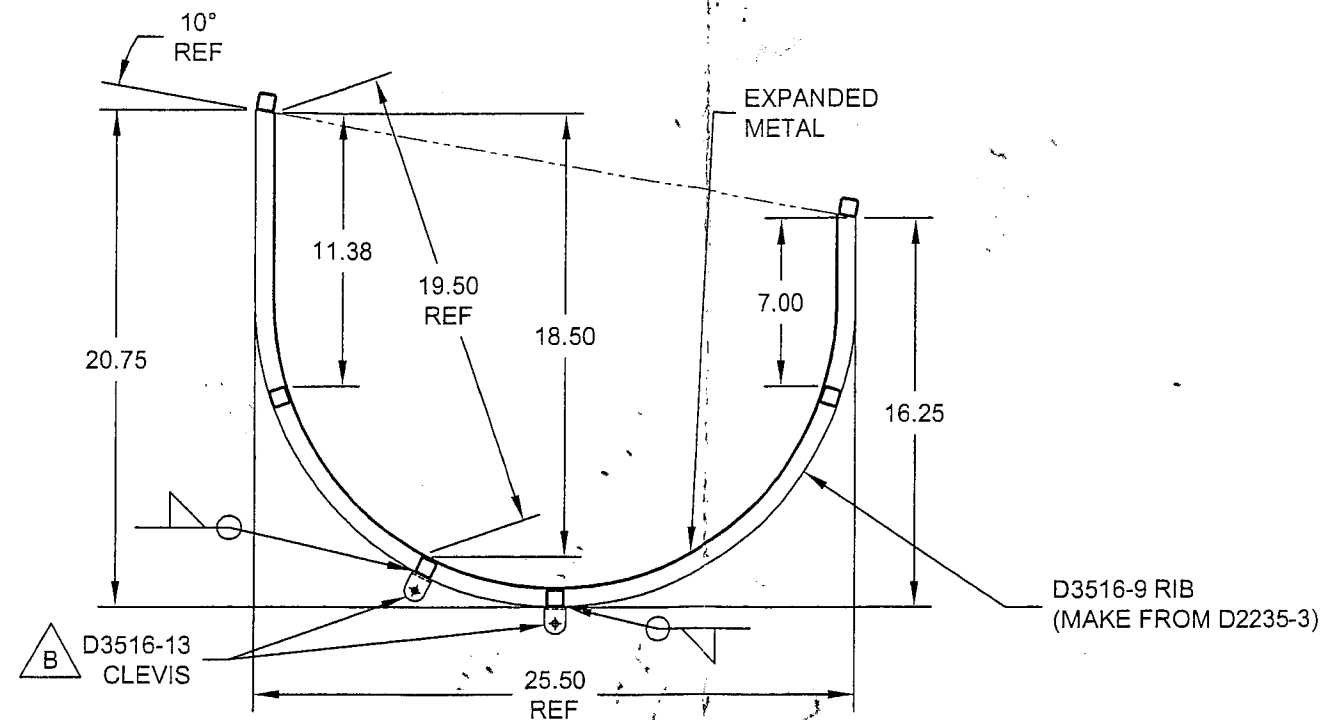
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 2 OF 4
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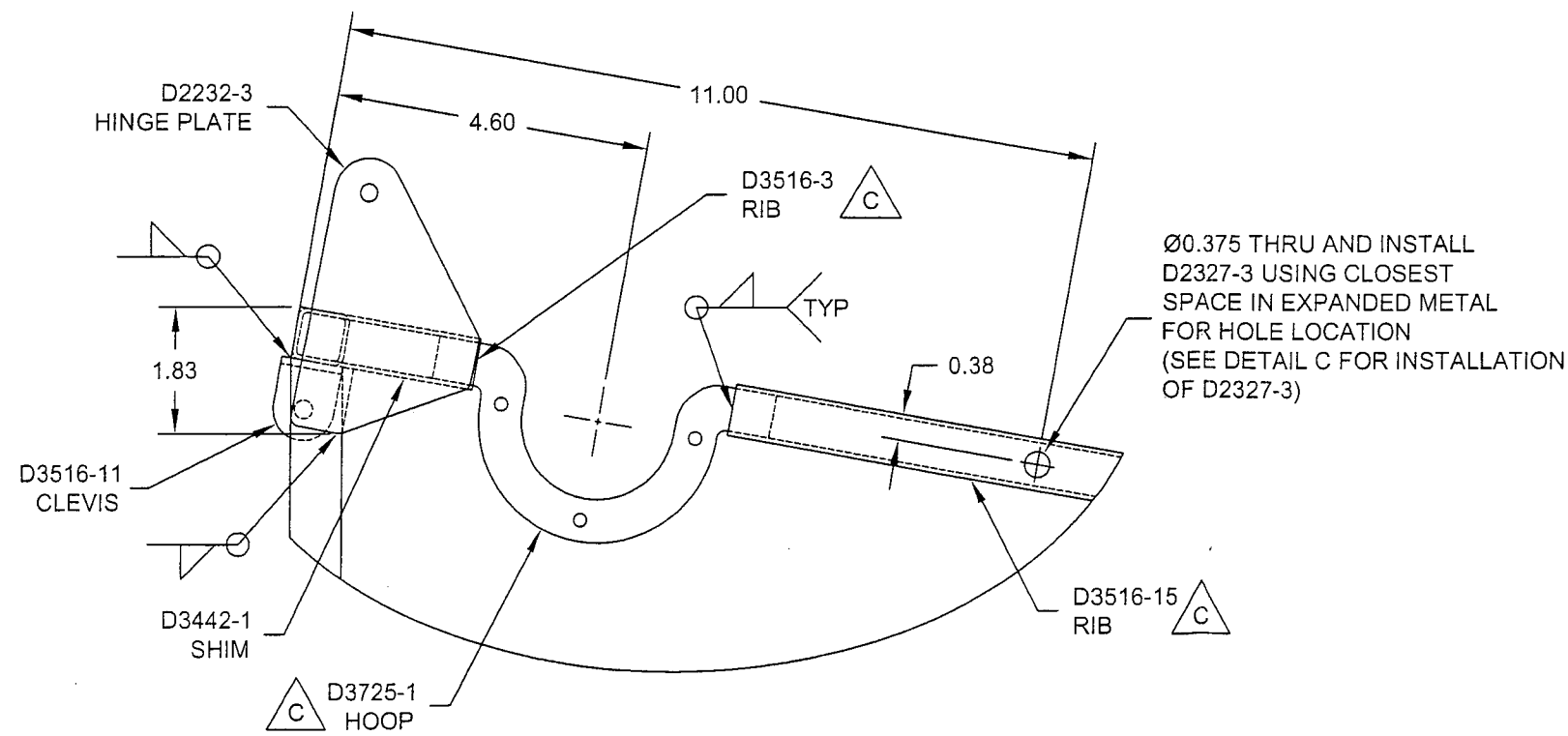




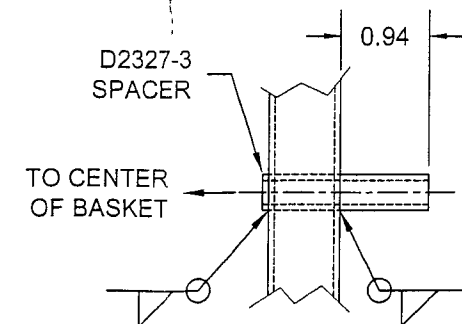
**SECTION A-A: END RIB DETAIL**  
TYP BOTH ENDS



**SECTION B-B: CENTER RIB DETAIL**  
2 PL



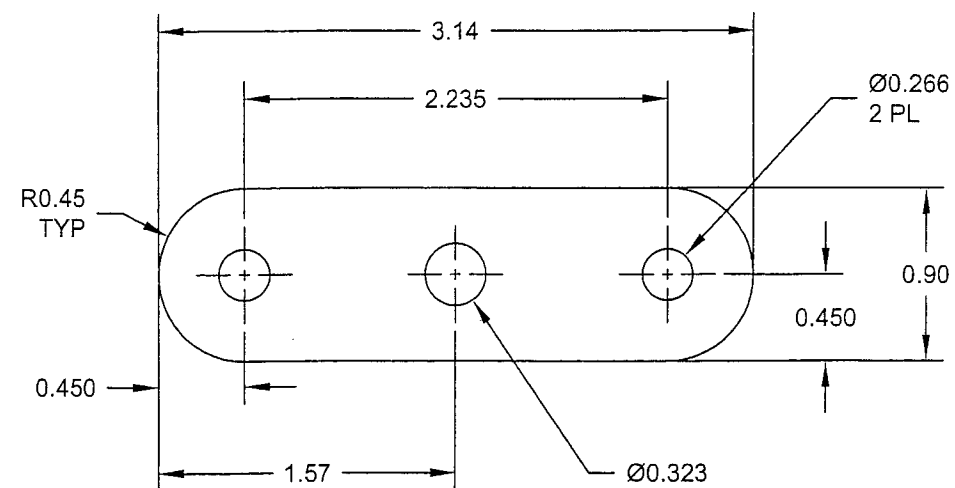
**DETAIL D: HOOP & HINGE PLATE DETAIL**  
FRONT SHOWN, BACK SIMILAR  
SCALE 3X



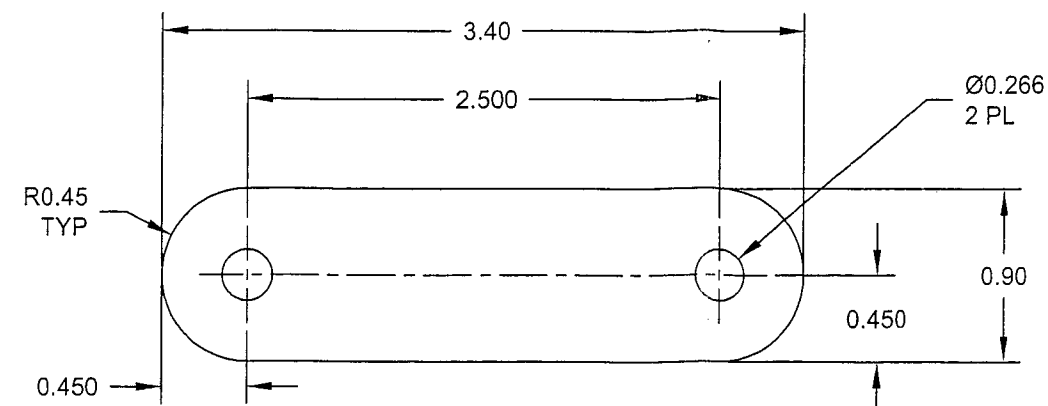
**DETAIL C: SPACER INSTALLATION**  
SCALE 4X

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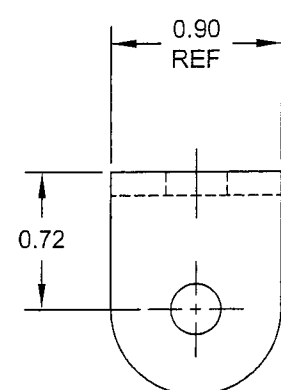
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CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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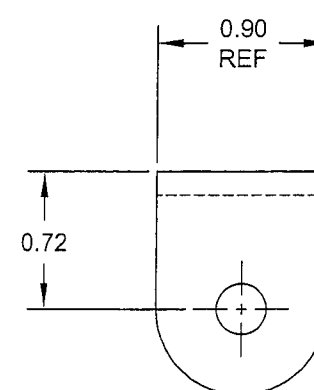
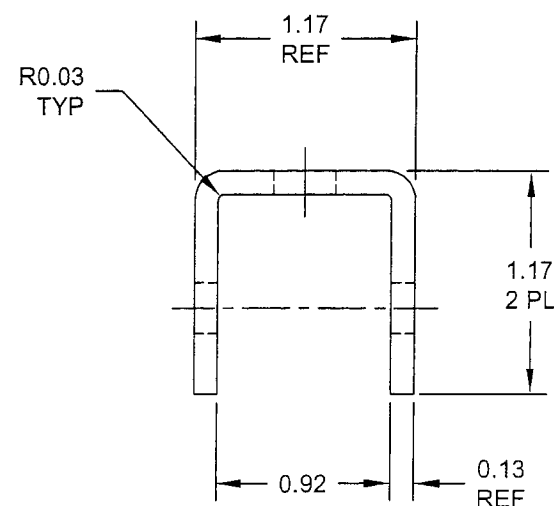
1 D3516-11F CLEVIS FLAT PATTERN



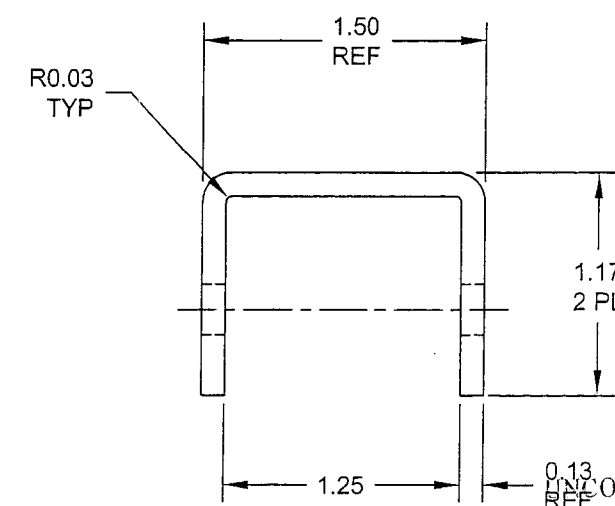
1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-13F)



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**D3516-11/-13 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs  
D3516-13 = 0.10 lbs

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